

**Work Order ID 58247**

Sunday, May 02, 2010 1:19:59 PM



SHIP

TUESDAY

Page 1

Item ID: D4030-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly (350)

Start Date: 5/3/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/4/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *mf*Date: *10-5-3*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4030	B								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

*PC 10/5/3 (1)**ES 10/05/04 (1)**Solo 10/04**(46)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 58247**

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Item ID: D4030-041

Accept

Revision ID:

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Start Date: 5/3/2010 Start Qty: 1.00

Required Date: 5/4/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg &amp; Stock Location:

0.00



Packaging

w/ 58248  
Memo

0.00

Packaging

D30-607-441

DPP 58248

10-5-4

SJ

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/04 AJ

mr

10-5-4

W/O:		WORK ORDER CHANGES					
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Work Order ID: 58247

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC  
per dwg revB DD 10.04.20 verified by:EC


IPP Rev:B as

Start Date: 5/3/2010

Required Date: 5/4/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2530  Handle Weldment		Manufactured	No			100	Each	4.0000	1			

Location Loc Qty Loc Code

ST506

4

57736

4

D2535  Spring		Manufactured	No			100	Each	13.0000	2			
---	--	--------------	----	--	--	-----	------	---------	---	--	--	--

Location Loc Qty Loc Code

ST504

13

56355

13

D2537  Bushing		Manufactured	No			100	Each	27.0000	4			
--	--	--------------	----	--	--	-----	------	---------	---	--	--	--

Location Loc Qty Loc Code

ST504

27

53181


7

57722

20

D3913-041 		Manufactured	No			100	Each	0.0000	1			
---	--	--------------	----	--	--	-----	------	--------	---	--	--	--

Long Basket Base Assembly, 350

D3914-041  


Manufactured	No			100	Each	0.0000	1					
--------------	----	--	--	-----	------	--------	---	--	--	--	--	--

Long Basket Lid Assembly (350)

B58237 (1x)

B58225 (1x)

EP 5/10/05/04

EP 5/10/05/04

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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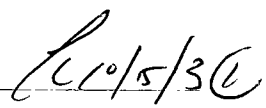
IPP Rev:B as

Start Date: 5/3/2010

Required Date: 5/4/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3917-3  Washer		Manufactured	No			100	Each	6.0000	6	 58186	14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST096		6						
				57144		6						
D3953-3  Gas Spring Stud, Lid		Manufactured	No			100	Each	9.0000	2	 57194	58	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST101		9						
				53757		3						
				57978		6						
D3953-7  Spring Spacer		Manufactured	No			100	Each	17.0000	2	 53767		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST101		17						
				53970		17						
D3953-9  Gas Spring Washer		Manufactured	No			100	Each	32.0000	2	 53970		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST101		32						
				53642		32						

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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IPP Rev:B as

Start Date: 5/3/2010

Required Date: 5/4/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3953-17  Gas Spring Spacer		Manufactured	No			100	Each	10.0000	2 ✓	<del>58/56</del> 17		
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST101				10				
					57143			10			57143	
D3953-19   Gas Spring Bracket		Manufactured	No			100	Each	14.0000	1		56324	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ST101				14				
					57607			14				
D3953-21  Gas Spring Bracket		Manufactured	No			100	Each	23.0000	1 ✓			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ENG				6				
					56407			6				
				ST102				17				
					57145			17			57145	
D3969-3  Spring (Basket Lid)		Manufactured	No			100	Each	4.0000	1 ✓			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				ENG				4				
					55716			4			55716	

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC  
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IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN3-14A  Bolt		Purchased	No			100	Each	102.0000	4			

Location Loc Qty Loc Code

ST351 102  
109754 2  
114330 100

109754 2  
114330

AN3-16A  Bolt		Purchased	No			100	Each	75.0000	2			
---------------------	--	-----------	----	--	--	-----	------	---------	---	--	--	--

Location Loc Qty Loc Code

ST352 75  
111965 5  
113845 50  
114523 20

111965

AN5-17A  Bolt		Purchased	No			100	Each	173.0000	4			
---------------------	--	-----------	----	--	--	-----	------	----------	---	--	--	--

Location Loc Qty Loc Code

ST323 68  
114324 68  
ST339 105  
113538 5  
114330 100

114324

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 5/3/2010

Required Date: 5/4/2010

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC  
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN4-12		Purchased	No			100	Each	56.0000	3			



Bolt

Location Loc Qty Loc Code

ST357 56

104016 6

114292 50

AN310-4

Purchased

No

100

Each

67.0000

3



NUT

Location Loc Qty Loc Code

ST139 30

114341 30

ST314 17

113845 17

ST349 20

114341 20

AN310C4

Purchased

No

100

Each

84.0000

2



Nut

Location Loc Qty Loc Code

ST349 84

114306 84

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 58247



Parent Item: D4030-041



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Start Date: 5/3/2010

Required Date: 5/4/2010

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC  
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No			100	Each	1,776.000	6	—		
Nut												

Location

Loc Qty

Loc Code

ST300

1776

113537

20

113644

756

114523

1000

113644

MS21042L5

Purchased

No

100

Each

701.0000

4



Nut

Location

Loc Qty

Loc Code

ST300

701

113523

26

113537

3

114108

172

114437

100

114449

400

114108

MS24665-151

Purchased

No

100

Each

704.0000

3



Cotter Pin

Location

Loc Qty

Loc Code

ST309

704

17566

704

17566

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 58247



Parent Item: D4030-041



Parent Item Name: Long Basket Assembly (350)

Start Date: 5/3/2010

Required Date: 5/4/2010

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC  
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IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS24665-300		Purchased	No			100	Each	94.0000	2	✓		



Cotter Pin



*lu*

Location	Loc Qty	Loc Code
ST309	94	
105279	2	
110123	92	

100	Each	93.0000	6
-----	------	---------	---

110123

NAS1149F0432P

Purchased

No

100

Each

93.0000

6



Washer



114576 1010/5/5

Location	Loc Qty	Loc Code
ST275	93	
112940	92	
114405	1	

100	Each	76.0000	4
-----	------	---------	---

NAS1149F0563P

Purchased

No

100

Each

76.0000

4



Washer



*lu*

Location	Loc Qty	Loc Code
ST275	76	
108471	76	

100	Each	959.0000	8
-----	------	----------	---

NAS1149F0332P

Purchased

No

100

Each

959.0000

8



WASHER



108471

10/5/3 0

Location	Loc Qty	Loc Code
ST275	959	
18057	959	

18057	959	
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18057

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IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
NAS1149C0432R		Purchased	No			100	Each	188.0000	2	—		



Washer



*[Signature]* 12/5/3 (2)

Location

Loc Qty

Loc Code

ST297

188

114292

188

114292

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

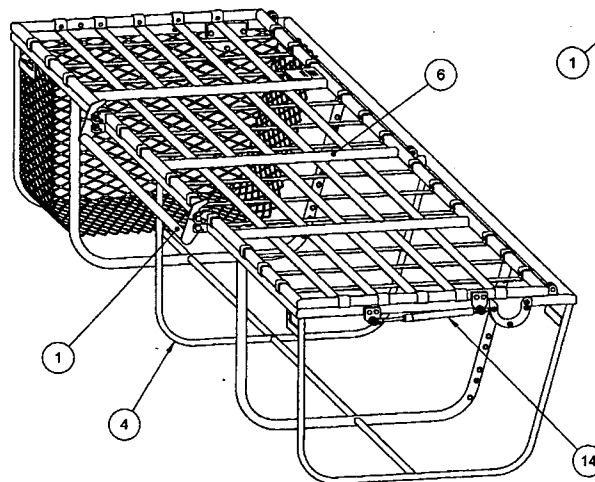
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

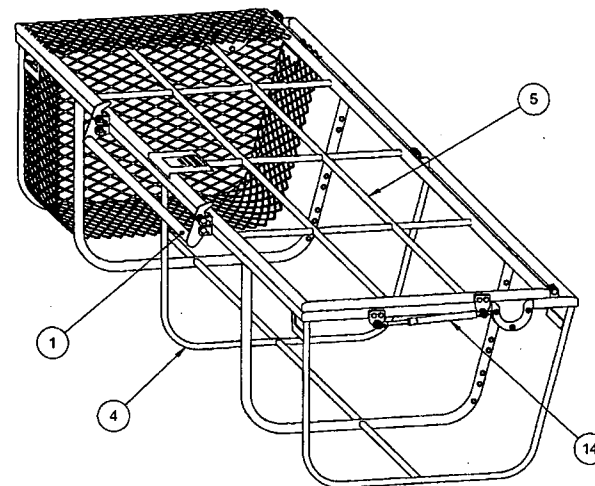
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**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	4	4	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8		NAS1149F0332P	WASHER
31	2		NAS1149C0432R	WASHER



**D4030-043 LONG BASKET ASSY, LIGHT LID (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)



**D4030-041 LONG BASKET ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX  
-043: 57 lbs APPROX

**RELEASED**  
2010-04-14

58247

B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	AM		
DE APPR.	JP		
DATE	10.04.06		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4030</b> TITLE <b>LONG BASKET ASSY (350)</b> REV. B SHEET 1 OF 3 SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

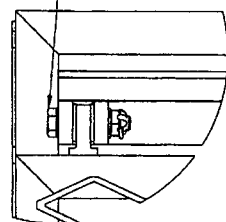
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

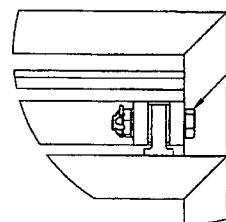
**NOTE:** Date & initial all entries



AN4-12 BOLT  
D3917-3 WASHER, 2X  
NAS1149F0432P WASHER, 2X  
AN310-4 NUT, CASTELLATED  
MS24665-151 COTTER PIN

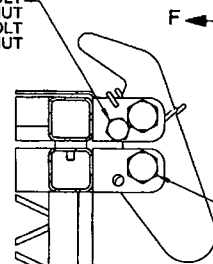


**DETAIL A** D8-2  
D5-2



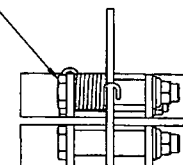
**DETAIL B** D3-2

D4030-041: AN3-16A BOLT  
MS21042L3 NUT  
D4030-043: AN3-20A BOLT  
MS21042L3 NUT



**SECTION C-C** B4-2  
B6-2

D4030-041: AN5-17A BOLT  
D2537 BUSHING  
D2535 SPRING  
NAS1149F0563P WASHER  
MS21042L5 NUT  
D4030-043: AN5-21A BOLT  
D2537 BUSHING  
D2535 SPRING  
NAS1149F0563P WASHER  
MS21042L5 NUT



**VIEW F-F** C3-3

AN5-17A BOLT  
D2537 BUSHING  
NAS1149F0563P WASHER  
MS21042L5 NUT

D2530  
HANDLE WELDMENT  
REF

D3953-17 GAS SPRING SPACER  
D3953-21 GAS SPRING BRACKET  
AN3-14A BOLT  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
2 PL

D3953-3 GAS SPRING STUD, LID  
D3953-7 GAS SPRING SPACER  
D3953-9 GAS SPRING SPACER  
NAS1149C0432R WASHER  
AN310C4 NUT, CASTELLATED  
MS24665-300 COTTER PIN

D3969-3 SPRING  
REF

**SECTION D-D** B2-2

D3953-17 GAS SPRING SPACER  
D3953-19 GAS SPRING BRACKET  
AN3-14A BOLT  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
2 PL

D3953-3 GAS SPRING STUD, LID  
D3953-7 GAS SPRING SPACER  
D3953-9 GAS SPRING SPACER  
NAS1149C0432R WASHER  
AN310C4 NUT, CASTELLATED  
MS24665-300 COTTER PIN

D3969-3 SPRING  
REF

**SECTION E-E** B1-2

**RELEASED**  
2010-04-14  
MP

58247

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. B
MFG. APPR.	GP	D4030	SHEET 3 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	LONG BASKET ASSY (350)	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries